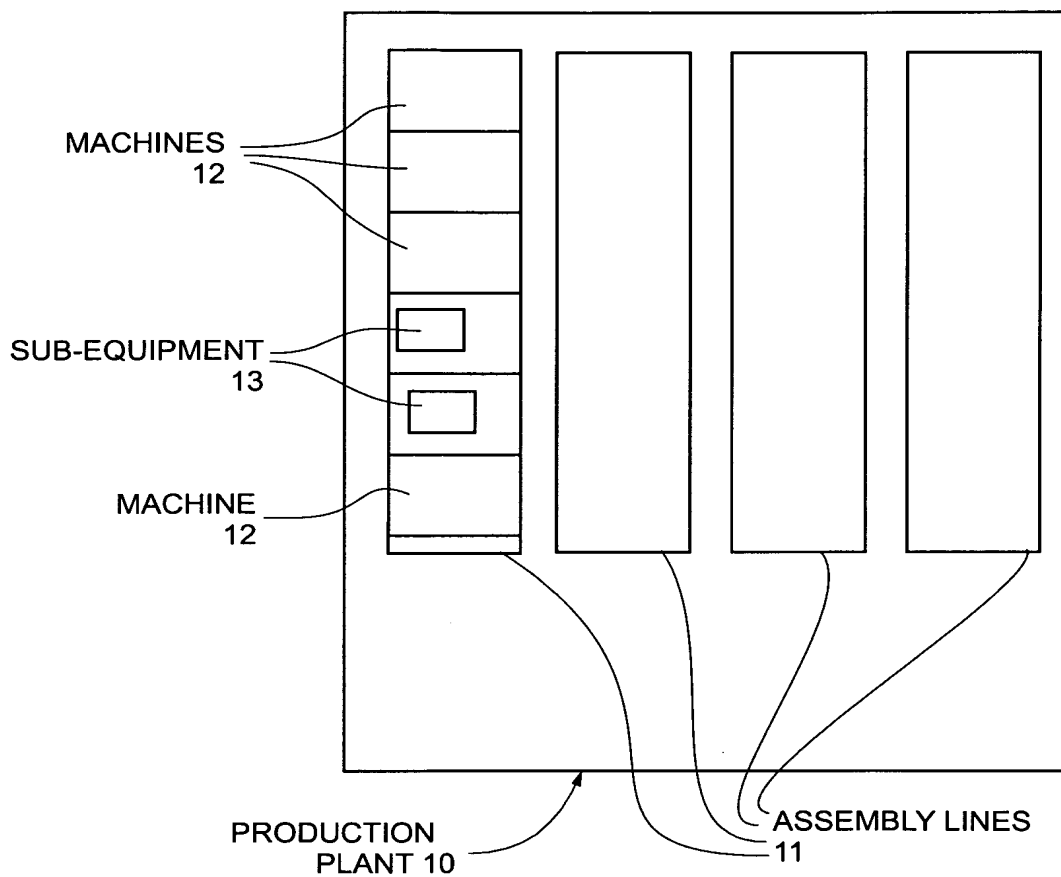
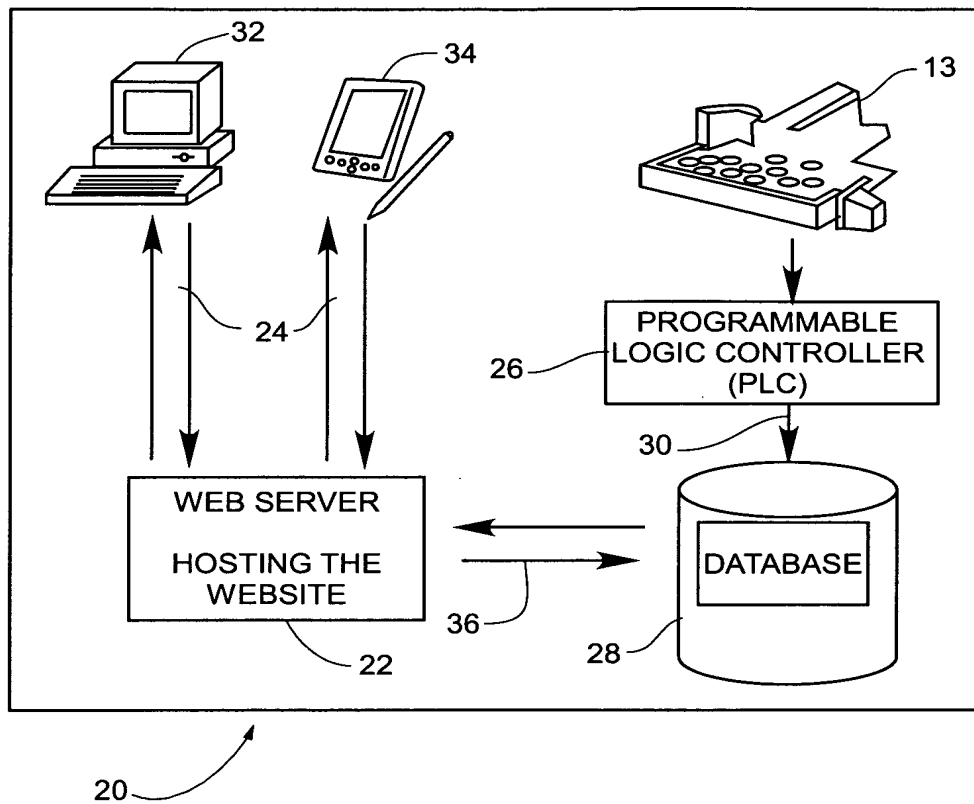




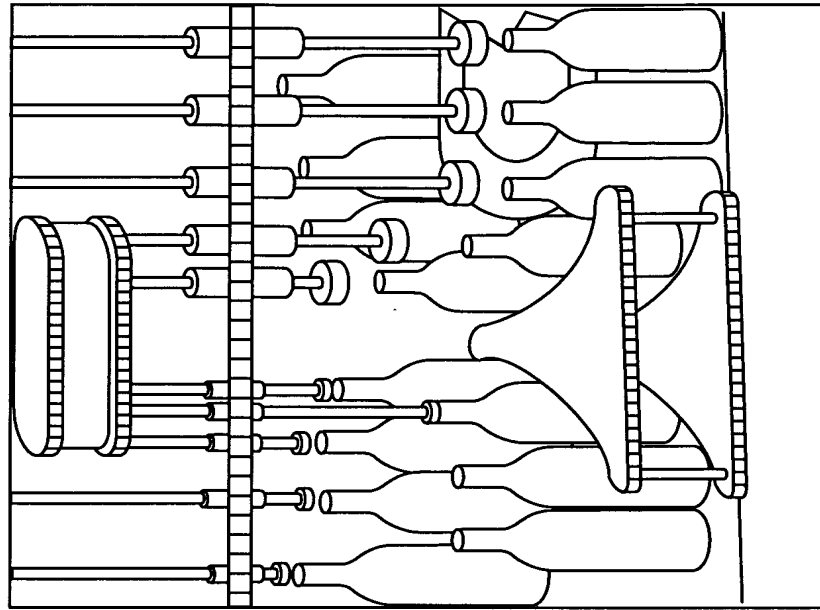
**Fig. 1**



**Fig. 2**

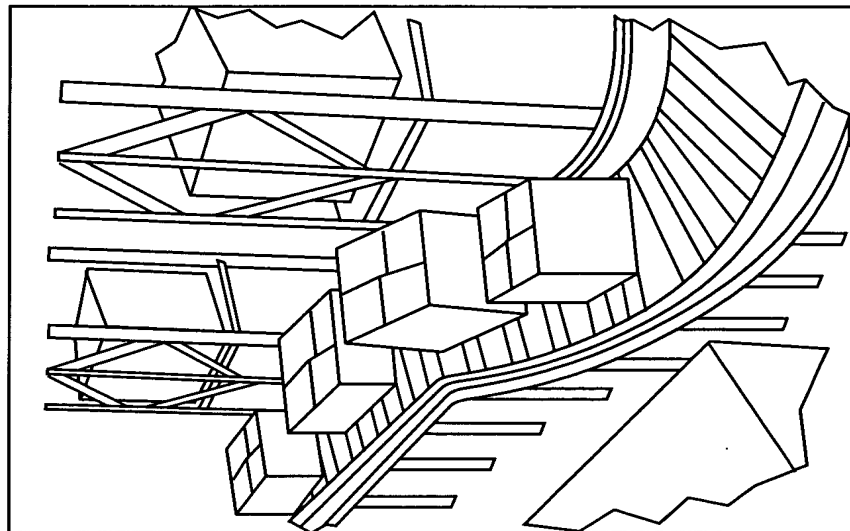


**Fig. 3B**



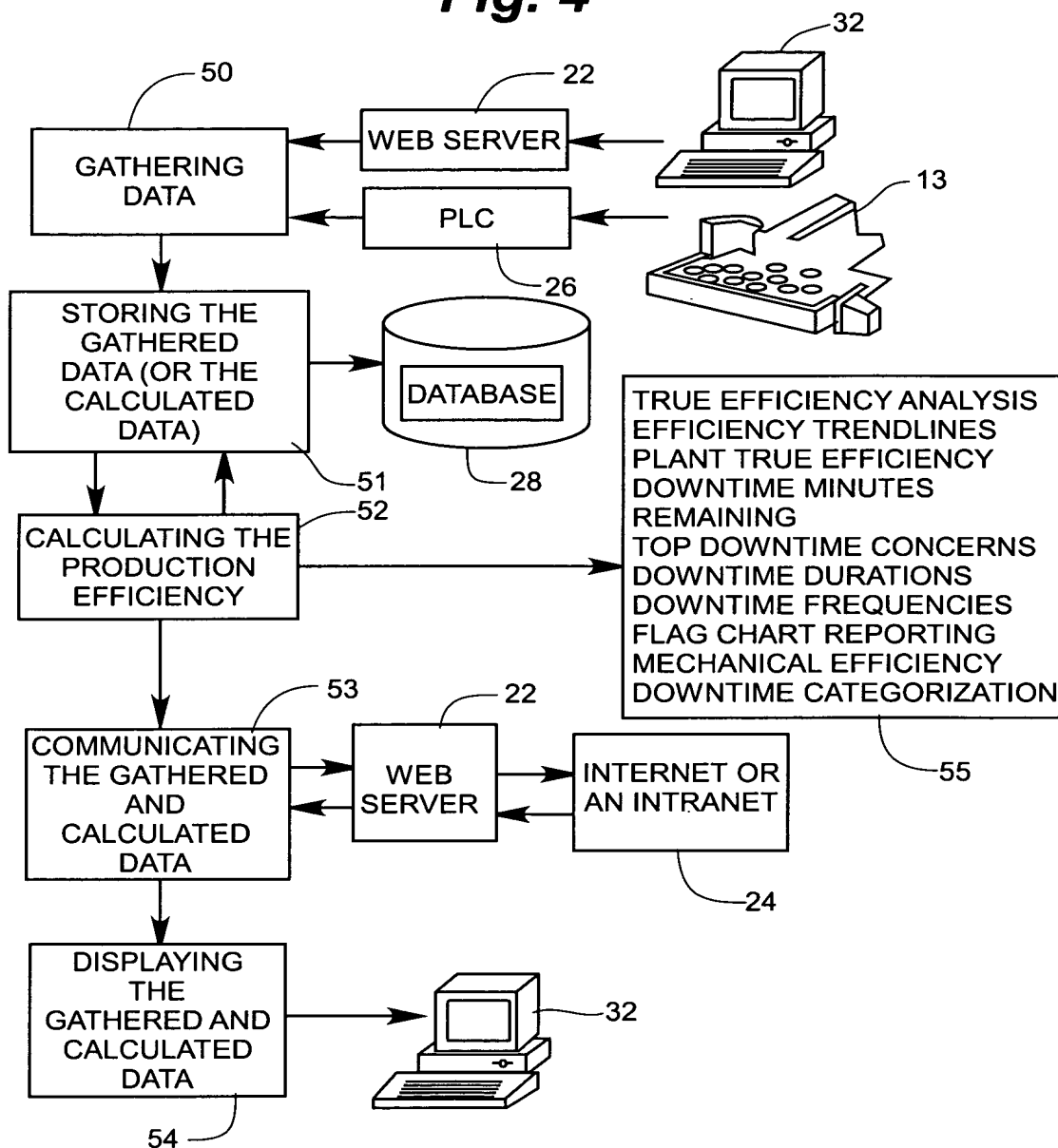
42

**Fig. 3A**

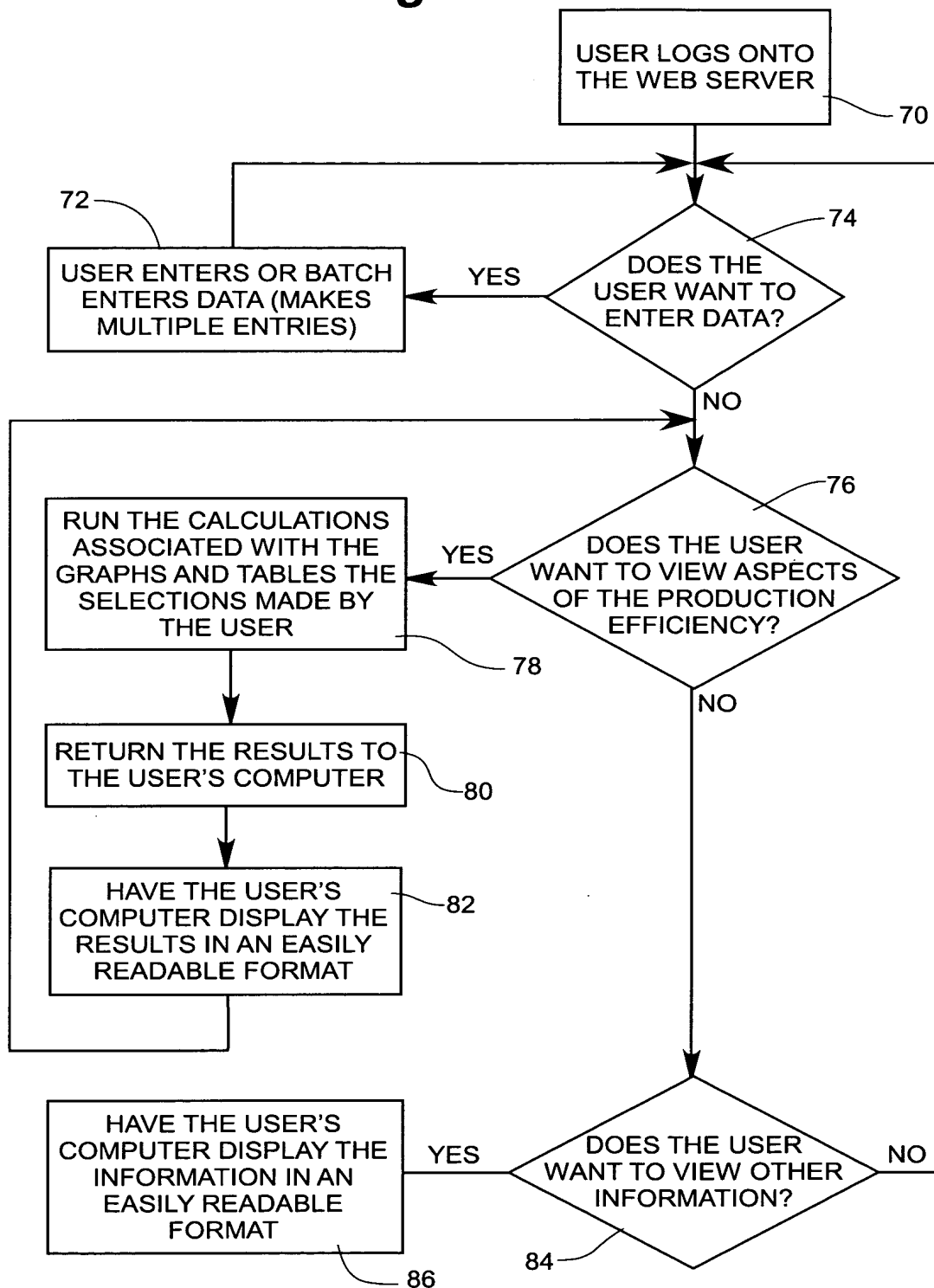


40

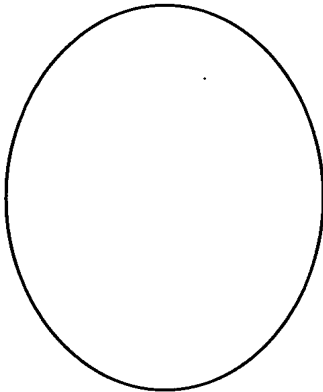
**Fig. 4**



**Fig. 5**

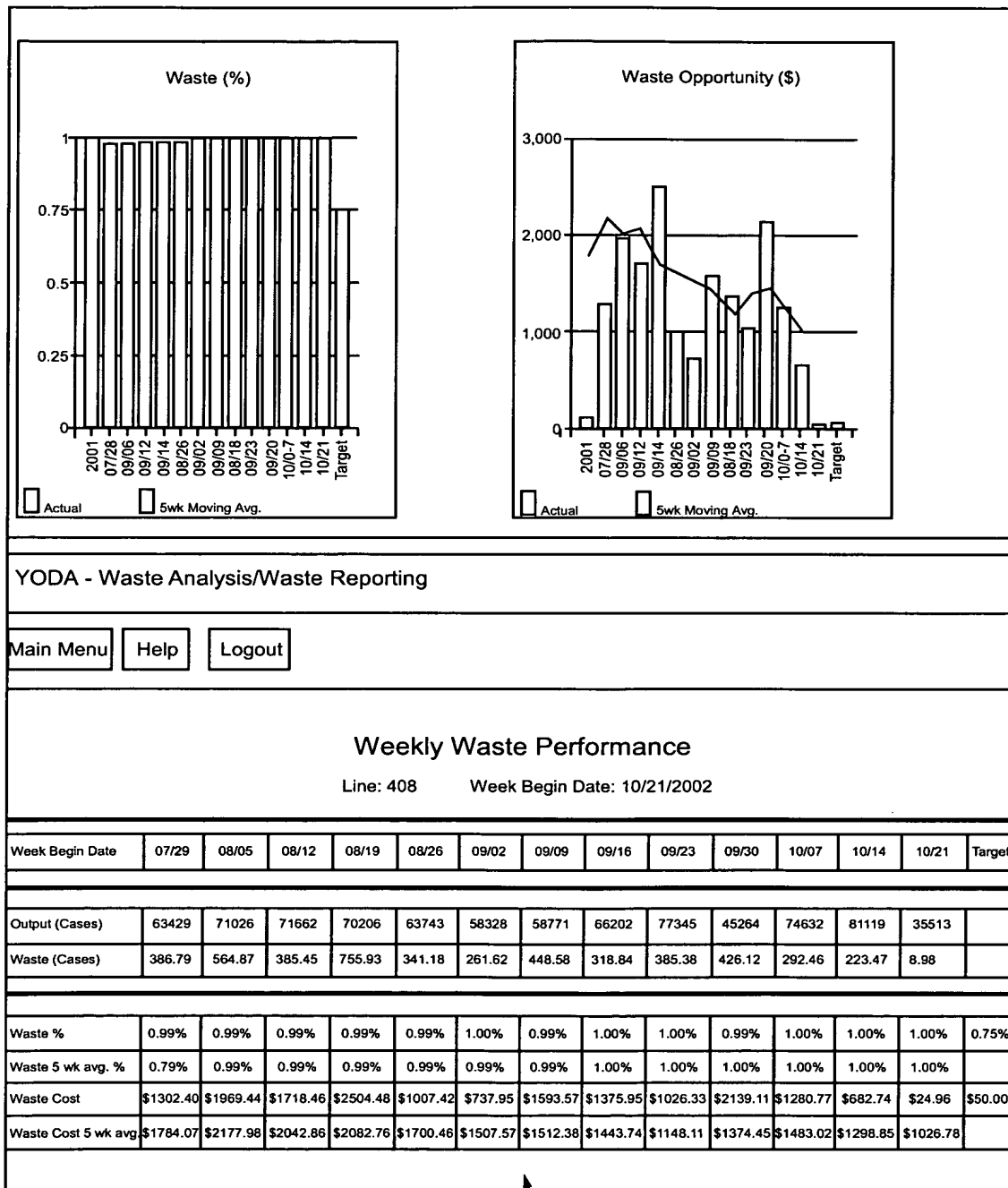


**Fig. 6**

|  |                                       |
|--|---------------------------------------|
| YODA - Microsoft Internet Explorer provided by The Quaker Oats Company   |                                       |
| File Edit View Fax Tool Help   |                                       |
|  |                                       |
| <input type="text"/>   |                                       |
| YODA - Main Menu   |                                       |
| <input type="button" value="Help"/>  | <input type="button" value="Logout"/> |
| <div><div><div>Downtime</div><div>Counter Measures</div><div>Waste Analysis</div><div>Reports</div><div>Maintenance</div></div><div></div><div>Welcome Yoda<br/>Version 1.0</div></div> |                                       |

100

**Fig. 7**



**Fig. 8**

YODA - Microsoft Internet Explorer provided by The Quaker Oats Company

File Edit View Fax Tool Help

YODA - Reports/Steering Pack

Main Menu

Reports

Held

Logout

[Go Back](#)

Performance Summary Report by Shift

Line 400 - #5 Jones      Week Begin 07-21-2003

|   | 21             | 22             | 23             | 24             | 25             | 26             | 27             | WB: 07-21-2003  |       |
|---|----------------|----------------|----------------|----------------|----------------|----------------|----------------|-----------------|-------|
|   | Monday         | Tuesday        | Wednesday      | Thursday       | Friday         | Saturday       | Sunday         | Total Per Shift |       |
|   | 3 1 2          | 3 1 2          | 3 1 2          | 3 1 2          | 3 1 2          | 3 1 2          | 3 1 2          | 3 1 2           | Total |
| Actual Output (Cases)                   | 2342 3236 2871 | 2037 2851 2833 | 2384 833       | 2037 2851 2833 | 2037 2851 2833 | 2037 2851 2833 | 2037 2851 2833 | 2037 2851 2833  | 29244 |
| Line Hours (Hours)                      | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00 | 8.00 8.00 8.00  | 108   |
| Capable Rate<br>(for each product code) | 4167 4167 4167 | 4167 4167 4167 | 4167 4167      | 4167 4167 4167 | 4167 4167      |                |                |                 |       |
| Downtime (mins)                         | 136 13 63      | 86 55 82       | 634 480 358    | 299 237 298    | 295 158        |                |                | 858 843 788     | 2805  |
| % Process Efficiency                    | 70% 87% 86%    | 79% 86% 70%    | 71% 0% 72%     | 37% 45% 33%    | 37% 44% 0%     | 0% 0% 0%       | 0% 0% 0%       | 42% 39% 38%     | 37%   |
| Lost time due to Downtime               | 30% 3% 14%     | 21% 14% 31%    | 28% 100% 88%   | 63% 55% 67%    | 63% 58% 100%   | 100% 100% 100% | 100% 100% 100% | 68% 61% 78%     | 63%   |

Bold = Default capable rate used, product code not found.  
Red = No outputs found at the beginning of the shift. They may be incorrect.

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Downtime Detail Report by Shift

Line 400 - #5 Jones      Week Begin 07-21-2003

|  | 21            | 22          | 23            | 24           | 25                | 26       | 27     | WB: 07-21-2003       |           |
|--|---------------|-------------|---------------|--------------|-------------------|----------|--------|----------------------|-----------|
|  | Monday        | Tuesday     | Wednesday     | Thursday     | Friday            | Saturday | Sunday | Total Per Shift      |           |
| Description                                  | 3 1 2         | 3 1 2       | 3 1 2         | 3 1 2        | 3 1 2             | 3 1 2    | 3 1 2  | 3 1 2                | Total     |
| 1. E. SCHEDULE<br>S. SCHEDULE<br>R. PM       | Mins<br>Stops |             | 480 80<br>1 2 |              |                   |          |        | 480 80<br>1 2        | 560<br>3  |
| 2. E. POUCHER<br>S. POUCHER<br>R. WEB AROUND | Mins<br>Stops | 3 11<br>1 2 | 13 3<br>3 1   | 9 14<br>3 2  | 9 38 81<br>3 5 11 | 74<br>4  |        | 108 38 100<br>145 16 | 255<br>35 |
| 3. E. POUCHER<br>S. POUCHER                  | Mins<br>Stops |             | 98<br>3       | 84 24<br>2 3 |                   |          |        | 84 122<br>2 6        | 206<br>8  |



**Fig. 9**

|  |     |          |          |                          |   |    |
|--|-----|----------|----------|--------------------------|---|----|
| YODA - Microsoft Internet Explorer provided by The Quaker Oats Company   |     |          |          |                          |   |    |
| File Edit View Fax Tool Help   |     |          |          |                          |   |    |
| YODA - Reports/Downtime Detail   |     |          |          |                          |   |    |
| <div>Main Menu Reports Held Logout</div>   |     |          |          |                          |   |    |
| <div>Go BackExport to Excel</div>  |     |          |          |                          |   |    |
| <div>Downtime Summary</div> <div>Line: 400</div> <div>Equipment: CARTONER</div> <div>Sub Equipment: CARTONER</div> <div>Reason Code: L-Shaped Carton Detector</div> <div>Date Range: 06/15/2003 - 07/12/2003</div> |     |          |          |                          |   |    |
|  |     |          |          |                          |   |    |
|  |     |          |          |                          |   |    |
|  |     |          |          |                          |   |    |
| 2061   | 400 | CARTONER | CARTONER | L-SHAPED CARTON DETECTOR | 6 | 18 |
| Total  |     |          |          |                          | 6 | 18 |
|  |     |          |          |                          |   |    |
|  |     |          |          |                          |   |    |